



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

D350-567-115
Job Sheet 172334



Part No: D350-567-115

Job Qty: 2 ea

Part Name: Replacement Interior Window



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 2/15/18

Job Tracking No:

Due Date: 3/2/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG DSI9745-011 REV A, IIN-D350-567 REV E SHEET 28 IPP Rev:A New Issue 04-08-24 JLM IPP Rev:B
CHG#2 ECN 1055 07-11-21 DD verified by:EC IPP Rev:C 08-10-07 as per revD DD verified by: IPP REV:D
13.10.15 AS PER IIN REV.E DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	2 Ea	3/2/18	3/2/18	0.00	0.00	Start Up Stores/Pkg-2		<i>SmB</i> FEB 22 2018
110	Packaging	2 pcs	3/2/18	3/2/18	0.00	0.00	Packaging1-3		<i>SmB</i> FEB 26 2018
120	QC	<i>DAS</i> 2 pcs	3/2/18	3/2/18	0.00	0.00	QC4		<i>SmB</i>
125	DC	<i>CHG#2 35</i> 2 pcs	3/2/18	3/2/18	0.00	0.00	DC		
130	Packaging	<i>9-89</i> 2 pcs	3/2/18	3/2/18	0.00	0.00	Packaging3-1		<i>SmB</i>
140	QC21-FG	2 Ea	3/2/18	3/2/18	0.00	0.00	<i>QC21</i>		<i>fg 033</i>

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
AN3-4A	Bolt	8 Ea (4 ea)	90-Start up Operation	
AN526C632R12	Screw	<i>DAS</i> 18 Ea (9 ea)	90-Start up Operation	
D2463	1/2" Seal (\$ Per Foot)	<i>38</i> 8.8200 ft (4.41 ea)	90-Start up Operation	
D3293-1	Doubler For Interior Window For -111	<i>9-89</i> 2 Ea (1 ea)	90-Start up Operation	
D3294-1	Bracket For Interior Window For -115	2 Ea (1 ea)	90-Start up Operation	
D3295-041	Replacement Interior Window For -111	2 Ea (1 ea)	90-Start up Operation	
D3296-041	Replacement Interior Door For -111	2 Ea (1 ea)	90-Start up Operation	
D5420-1	Doubler Plate	2 Ea (1 ea)	90-Start up Operation	
DT8439	Template	2 (1 ea)	90-Start up Operation	
MS20426AD3-5	Rivet	16 Ea (8 ea)	90-Start up Operation	
MS20470AD4-5	Rivet, Universal Head	4 Ea (2 ea)	90-Start up Operation	
MS20470AD4-6	Rivet, Universal Head	230 Ea (115 ea)	90-Start up Operation	
MS20470AD4-7	Rivet, Universal Head	30 Ea (15 ea)	90-Start up Operation	
MS21042L06	Nut	18 Ea (9 ea)	90-Start up Operation	
MS21062L3	Nut Plate	8 Ea (4 ea)	90-Start up Operation	
NAS1149DN632J	Washer	18 pcs (9 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	AN3-4A	8	328	0
	AN526C632R12	18	213	0
	D2463	9	479	0
	D3293-1	2	12	0

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS <table style="width:100%;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																	
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DART Aerospace Ltd. 1270 Aberdeen Street Highway 107, ON K6A 1K7 CANADA TEL: 1 613 832-5200 Email: sales@dartaero.com www.dartaerospace.com DART AEROSPACE Container No: S044681 Part: D350-567-115 Job No: 172334 Serial No/Batch: S044681 Revision: DS19745-011, IIN-D350-567 Inspector: _____ Date: 02/22/18		Completed By																																																																			
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D3294-1	2	12	0
D3295-041	2	6	0
D3296-041	2	1	0
D5420-1	2	2	0
DT8439	2	0	0
MS20426AD3-5	16	8,436	0
MS20470AD4-5	4	1,482	0
MS20470AD4-6	230	3,357	0
MS20470AD4-7	30	1,233	0
MS21042L06	18	185	0
MS21062L3	8	31	0
NAS1149DN632J	18	452	0

Part Specifications

Specifications could not be found.

Plex 2/15/18 12:56 PM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____

Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐ Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐	AGAINST DEPARTMENT/PROCESS		
Date : _____	Step #: _____	QTY Effective : _____	MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		
		Completed By		
		Lead hand / Supervisor Approval Verification		
		QC / QA Coordinator Approval		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : _____				



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Master Unit 001124

Tel (613) 632-5200

Containers on Master Unit 001124				
Serial No	Part No	Customer Part No	Status	Quantity
S044668	AN3-4A		Allocated	8
S006311	AN526C632R12		Allocated	4
S044667	AN526C632R12		Allocated	14
S044665	D2463	D2463	Allocated	4.41
S044666	D2463	D2463	Allocated	4.41
S044664	D3293-1	D3293-1	Allocated	2
S044663	D3294-1		Allocated	2
S041140	D3295-041*	D3295-041	Allocated	2
F162897	D5420-1		Allocated	2
S044652	MS20426AD3-5		Allocated	16
S044651	MS20470AD4-5		Allocated	4
S044650	MS20470AD4-6	MS20470AD4-6	Allocated	230
S044647	MS20470AD4-7		Allocated	30

F1134370-4	MS114900325			2
S044643	MS1149006325			16
S024472	MS21062L3			8
S044650	MS21042L06			18
S042807	D3296-041			2

PAGE 1 OF 1

Description: REPLACEMENT INTERIOR FLOOR WINDOW

H:\Forms\Engineer\Approved Eng Online\CHGREC revB

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐

REFERENCE ONLY

5.0 PARTS LIST

Qty -015	Qty -017	Qty -025	Qty -027	Qty -111	Qty -117	Part Number	Description
X						D350-567-015	FLOOR WINDOW INSTALLATION (SMALL)
	X					D350-567-017	FLOOR WINDOW INSTALLATION (SMALL)
		X				D350-567-025	FLOOR WINDOW INSTALLATION (LARGE)
			X			D350-567-027	FLOOR WINDOW INSTALLATION (LARGE)
				X		D350-567-111	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
					X	D350-567-117	FLOOR WINDOW INSTALLATION (EXTRA LARGE)
1	1					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
		1	1			D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
				1	1	D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
	1		1	1		D350-567-115	INTERIOR FLOOR WINDOW KIT
1		1			1	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)

Qty -013	Qty -023	Qty -113	Qty -115	Qty -031	Part Number	Description
X					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
	X				D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
		X			D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
			X		D350-567-115	INTERIOR FLOOR WINDOW KIT
				X	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)
1					D2125	REPLACEMENT WINDOW, SMALL
	1				D2942	REPLACEMENT WINDOW, LARGE
		1			D3290-041	REPLACEMENT WINDOW ASSEMBLY, EXTRA LARGE
1					D2126-0600	SEAL
	1				D2463-0750	NEOPRENE SEAL
		1			D2463-0860	NEOPRENE SEAL
	9	12			2600-6	¼ TURN FASTENER
	9	12			2600-LW	WASHER
	9	12			212-12	RECEPTACLE
	22	21			AN526C832R9	SCREW (OR AN526C832-9, OR MS51957-126)
	44	42			AN960JD8	WASHER
	22	21			MS21042L08	NUT (OR MS21042-08)
	18	24			MS20426AD3-5	RIVET
2 SQ. YD	2 SQ. YD	2 SQ. YD			N/A	9.7oz 7781 'S' GLASS UNIVERSAL WEAVE
				1	D2463-0450	NEOPRENE SEAL
				1	D3210-1	DOUBLER
				1	D3211-1	BRACKET
				1	D3212-1	FLOOR WINDOW
				1	D3213-041	DOOR ASSEMBLY
			1		D3293-1	DOUBLER
			1		D3294-1	BRACKET
			1		D3295-041	FLOOR WINDOW
			1		D3296-041	DOOR ASSEMBLY
			1		D2463-0530	NEOPRENE SEAL
			9	8	AN526C632R12	SCREW (OR AN526C632-12, OR MS51957-32)
			9	8	AN960JD6	WASHER
			9	8	MS21042L06	NUT (OR MS21042-06)
			2	40	MS20470AD4-5	RIVET
			115	90	MS20470AD4-6	RIVET
			15	20	MS20470AD4-7	RIVET

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Revision: E

Date: 13.08.15

EDIT 5.0/25.7 PARTS LIST:

For customers with kits D350-567-013/-015/-017/-023/-025/-027/-117 @ CHG002 and earlier,
Customers with kits D350-567-111 @ CHG006 and earlier,
Customers with kits D350-567-115 @ CHG004 and earlier,
Customers with kits D350-567-031/-031B/-111B/-115B @ CHG001 and earlier,
Procure kit DSI 9745-011

Item	Qty -011	Part Number	Description
	X	DSI 9745-011	FIRE EXTINGUISHER RELOCATION KIT
1	1	D5420-1	DOUBLER PLATE
2	4	AN3-4A	HEX HEAD BOLT
3	8	MS20426AD3-5	CSK RIVET
4	4	MS21062L3	NUTPLATE

For customers with kits D350-567-013/-015/-017/-023/-025/117 @ CHG003 and later,
Customers with kits D350-567-111 @ CHG007 and later,
Customers with kits D350-567-115 @ CHG005 and later,
Customers with kits D350-567-031/-031B/-111B/-115B @ CHG002 and later,
Refer to Installation Instructions D350-567 and ICA-D350-567 and update the parts list as follows:

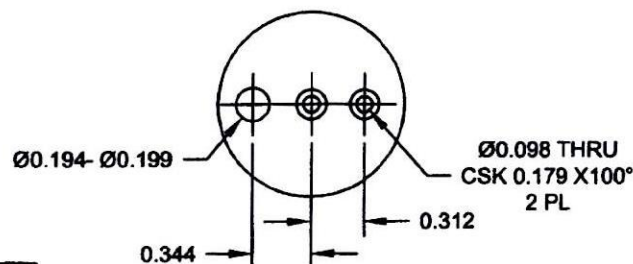
EDIT 5.0 ADD:

Qty -013	Qty -023	Qty -113	Qty -115	Qty -031	Part Number	Description
X					D350-567-013	REPLACEMENT WINDOW KIT (SMALL)
	X				D350-567-023	REPLACEMENT WINDOW KIT (LARGE)
		X			D350-567-113	REPLACEMENT WINDOW KIT (EXTRA LARGE)
			X		D350-567-115	INTERIOR FLOOR WINDOW KIT
				X	D350-567-031	INTERIOR FLOOR WINDOW KIT (SLIDING DOOR COMPATABLE)
			1	1	D5420-1	DOUBLER PLATE
			4	4	AN3-4A	HEX HEAD BOLT
			8	8	MS20426AD3-5	CSK RIVET
			4	4	MS21062L3	NUTPLATE

EDIT 4.0/25.5 WEIGHT AND BALANCE:

*Note: Does not include fire extinguisher weight

Installation	Weight	LATERAL		LONGITUDINAL	
		Arm	Moment	Arm	Moment
DSI 9745-011 (Primary Location)	0.1 lb	+1.6 in	+16 in lb	72.2 in	7.2 in lb
Fire Extinguisher Relocation Kit	0.05 kg	+0.04 m	+0.02 m kg	1.83 m	0.1 m kg
DSI 9745-011 (Alternate location)	0.1 lb	-4.4 in	-44 in lb	65.4 in	6.5 in lb
Fire Extinguisher Relocation Kit	0.05 kg	-0.11 m	-0.01 m kg	1.66 m	0.1 m kg

**DETAIL A**

(NUT PLATE HOLE PATTERN)

CANADA DEPARTMENT OF TRANSPORT AIRCRAFT CERTIFICATION BRANCH DAO # 01-O-01	
APPROVED	
BY:	<i>[Signature]</i>
D. SHEPHERD (DE # 02)	
DATE:	16.04.06
CERT. NO.:	SH92-18
ISSUE NO.:	6

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9745	SHEET 2 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	ALTERNATE FIRE EX LOCATION	NTS
DATE	16.04.06	COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	